

Work Order ID 129845

February-23-15 10:26:46 AM

129845

Page 1

Item ID: D120-639-021

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: OEM Replacement Wearplate (s/n 1391 and sub)

Start Date: 2/13/15 Start Qty: 1.00 3. *1*

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-02-25 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9623	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D120-639-021 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

MLJ 15-02-09
3

DAS
46
9-89

MAR 09 2015

3x

DAS
27
9-89

MAR 09 2015

3

DAS
46
9-89

MAR 09 2015

3x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129845***129845***

Page 2

February-23-15 10:26:46 AM

Item ID: D120-639-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: OEM Replacement Wearplate (s/n 1391 and sub)

Start Date: 2/13/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/23/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D120-639-021

Location: 66137A

(3)

DAS
46
9-89

MAR 09 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 15-03-10

(15-3-10)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:26:44 AM

Page 1

Work Order ID: 129845

129845

Parent Item: D120-639-021

D120-639-021

Parent Item Name: OEM Replacement Wearplate (s/n 1391 and sub)

Start Date: 2/13/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.07.04 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2648-3 *D2648-3* Wearpad	DAS 46 9-89	Manufactured	No			110	Each	34.0000	5	15		DAS 27 9-89 MAR 09 2015	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				8					
				85490				8					
				ST601				26					
				119444				26					
D2656-13 *D2656-13* Wearpad Fwd	DAS 46 9-89	Manufactured	No			110	Each	4.0000	1	3		DAS 27 9-89 MAR 09 2015	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST603				4					
				101555				2					
				105308				2					
D2746 *D2746* Wearplate	DAS 46 9-89	Manufactured	No			110	Each	4.0000	1	3		DAS 27 9-89 MAR 09 2015	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST601				4					
				86438				1					
				91907				3					
D4677-1 *D4677-1* Wearplate, Aft	DAS 46 9-89	Manufactured	No			110	Each	4.0000	1	3		DAS 27 9-89 MAR 09 2015	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST605				4					
				127842				4					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:26:45 AM

Page 2

Work Order ID: 129845

129845

Parent Item: D120-639-021

D120-639-021

Parent Item Name: OEM Replacement Wearplate (s/n 1391 and sub)

Start Date: 2/13/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

AELS8-1032-130 Purchased

No

110

Each

6,426.000

38

~~38~~ 114

AI S7-1032-130

Rivnut

DAS
46
9-89

**

DAS
27
9-89

MAR 09 2015

Location

Loc Qty

Loc Code

CA

6

M128649

6

CCK003

6320

M128649

6320

FG

100

121444

100

114

MS27039-1-08

Purchased

No

110

Each

1,370.000

38

~~38~~ 114

MS27039-1-08

Screw

DAS
46
9-89

**

DAS
27
9-89

MAR 09 2015

Location

Loc Qty

Loc Code

CA

96

m128636

96

FP001

498

m128636

498

GA

2

125654

2

ST285

774

m128636

774

114

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

February-23-15 10:26:45 AM

Page 3

Work Order ID: 129845

129845

Parent Item: D120-639-021

D120-639-021

Parent Item Name: OEM Replacement Wearplate (s/n 1391 and sub)

Start Date: 2/13/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

2,335.000

38

~~38~~ 114

NAS1149D0332.J

DAS

46

Washer

9-89

DAS

27

MAR 09 2015

DAS
9-89

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

2321

112794

16

m130325

1305

m131624

1000

114

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D120-639 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D120-639 REV. 0
REF TCCA STC: SH01-25
REF FAA STC: SR01347NY
REF EASA STC: EASA.IM.R.S.01452

UNCO
SUBMIT
N. 129845
15-08-25
MCS
COPY
INMENT

1.0 PURPOSE

It has come to Dart's attention that the D120-639-011/-013 Wearplate Kits can't be installed as intended on recent EC 120B aircraft due to a Eurocopter design change on the spring blade located at the aft end of the skidtube. This Dart Service Instruction (DSI) introduces the new D120-639-021 Wearplate Kit (fits one skidtube) for customers with aircraft equipped with the new style spring blades. The D120-639-021 Wearplate Kits should be installed in pairs (one per skidtube).

2.0 INSTALLATION

- 2.1 Remove existing wearplates and plug all unused holes with the screws that were just removed.
- 2.2 Remove and retain DHS411-101-2076 Bolt and associated hardware securing the spring blade per aircraft maintenance manual.
- 2.3 Locate D4677-1 Wearplate using DHS411-101-2076 Bolt removed at Step 2.2 as shown in Figure 1 of this service instruction. Locate D2746 and D2656-13 Wearplates as shown in Figure 1. Adjust the amount of overlap between the wearplates to ensure that the wearplate holes do not interfere with any existing holes in the skidtube. Temporarily clamp the wearplates into the proper position.
- 2.4 Using the wearplates as a template, drill $\varnothing 0.125$ holes in the center of the wearplate obrounds. To help maintain position of the wearplates during the drilling operation, it is recommended to cleco the wearplates to the skidtube as the pilot holes are drilled. Remove wearplates after all pilot holes are drilled.
- 2.5 Open holes drilled in previous step to $\varnothing 0.297$ and deburr. Remove swarf from inside of skidtube. Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install ALS7-1032-130 inserts.
- 2.6 Install the D2656-13, D2746, and D4677-1 Wearplates and D2648-3 Wearpads using the MS27039-1-08 Screws and NAS1149D0332J Washers. Seal all screws with Sikaflex-241/291 (or Proseal 890) sealant before installing. Re-install the DHS411-101-2076 Bolt and associated hardware and torque to 44.3-61.9 in-lb (5.0 7.0 N-m). Note: It is acceptable to omit the washer(s) on DHS411-101-2076 Bolt to ensure 1.5-4 threads in safety. It is acceptable to trim the D4677-1 Wearplate as required to clear the aft saddle.
- 2.7 Adjust weight and balance in accordance with Section 4.0 below.

3.0 MAINTENANCE

Maintain the D120-639-021 Wearplate Kit in accordance with ICA-D120-639 Rev. 0 or later approved revision.

4.0 WEIGHT AND BALANCE

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D120-639-021 WEARPLATE KIT	3.2 lb 1.5 kg	136.0 in 3.45 m	435 in-lb 5.2 m-kg	± 40.7 in ± 1.03 m	± 130 in-lb ± 1.5 m-kg

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH01-25
ISSUE NO.: 1

A	NEW ISSUE	MB	12.06.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	DSI 9623	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE KIT	NTS
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5.0 PART LIST

Qty -021	Part Number	Description
X	D120-639-021	WEARPLATE KIT
5	D2648-3	WEARPAD
1	D2656-13	WEARPLATE
1	D2746	WEARPLATE
1	D4677-1	WEARPLATE
38	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
38	MS27039-1-08	SCREW
38	NAS1149D0332J	WASHER

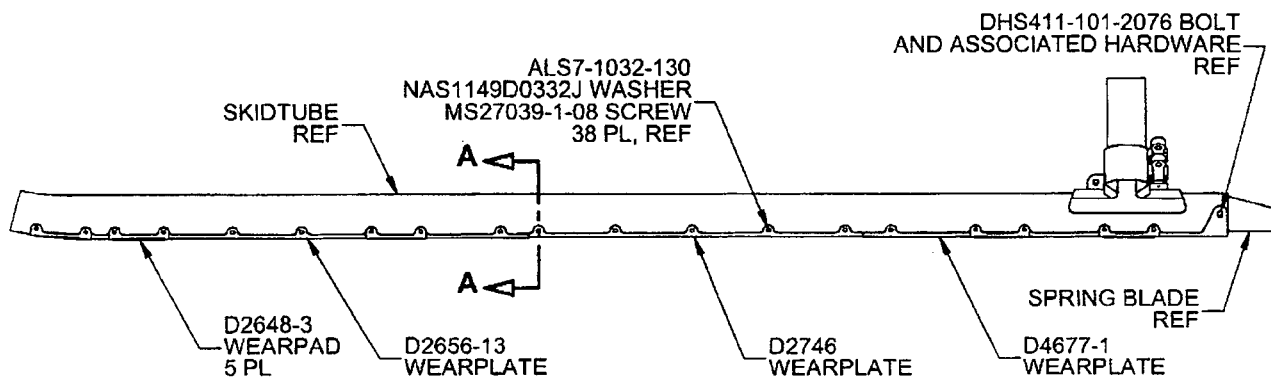
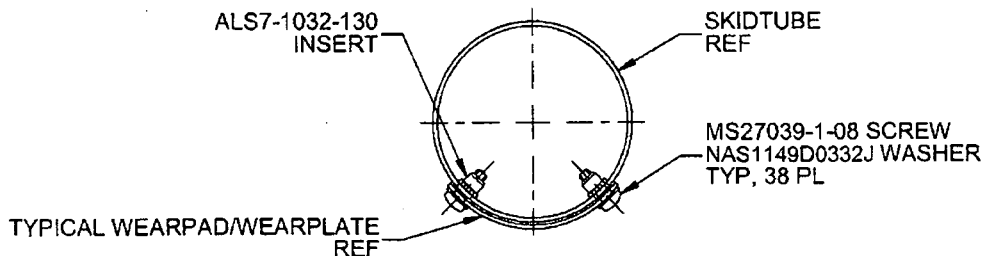


FIGURE 1: D120-639-021 WEARPLATE KIT INSTALLATION



SECTION A-A: TYPICAL SKIDTUBE SECTION

SCALE 4X

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *DMS*
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH01-25
ISSUE NO.: 1

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MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 2
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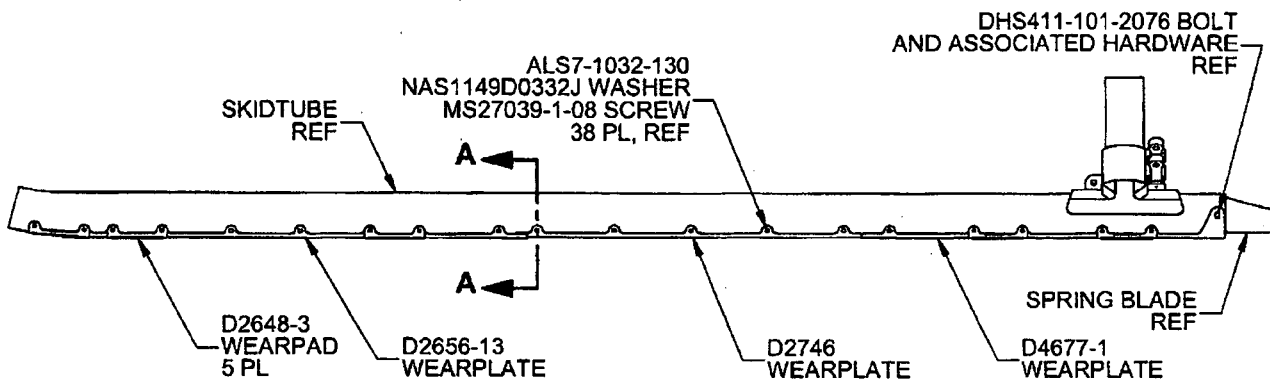
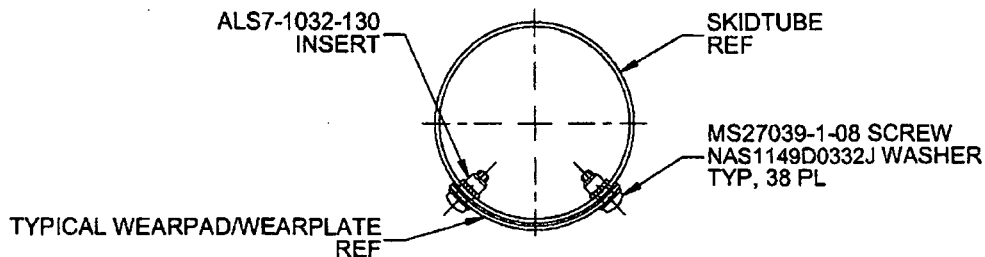


FIGURE 1: D120-639-021 WEARPLATE KIT INSTALLATION



SECTION A-A: TYPICAL SKIDTUBE SECTION

SCALE 4X

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BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

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